

TECHNICAL DATASHEET

TRILOY® 180

PC/PBT (Non-Painting)

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.22
Water Absorption (24 hours at 23℃)	%	D570	0.15
Melt Flow Rate (250℃, 5kg)	g/10min	D1238	32
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	620
Tensile Elongation at break	%	D638	120
Flexural Strength at yield	kg _f /cm ²	D790	880
Flexural Modulus	kg _f /cm ²	D790	22,500
Izod Impact Strength, notched, 23℃ (1/8")	kg _f ·cm/cm	D256	60
THERMAL			
HDT, 18.6 kg _f /cm ²	℃	D648	110
ELECTRICAL			
OTHERS			
Mold Shrinkage (3mm thickness)	%	D955	0.7~1.2

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRILOY® 180 GRADE

PC/PBT (Non-Painting)

- General processing conditions for TRILOY180 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	90~100
Drying Time	hr	3~4
Moisture Content, Max	%	0.02
Melt Temperature	℃	250~270
Nozzle Temperature	℃	260~280
Front Temperature	℃	260~280
Middle Temperature	℃	240~260
Rear Temperature	℃	230~250
Mold Temperature	℃	50~70
Back Pressure	MPa	0.3~0.7
Screw Speed	rpm	30~70
Vent Depth	mm	0.02~0.08

Global Network

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